

Work Order ID 59078

May 26, 2010 8:58:16 AM



Page 1

Item ID: D350-607-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/03/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D350-607-2

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-441 CHG001

8 106664

10 for CL 10/06/02

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Pickup 10/06/02

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 106664

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPPD350-607-441								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

PART

10/6/40

10/6/40

MF
10-6-4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May 26, 2010 8:58:14 AM

Page 1

Work Order ID: 59078

Parent Item: D350-607-441

Parent Item Name: Heli-Utility-Basket

Comments: IPP REV:A NEW ISSUE 10-04-05 JLM VERIFIED BY:DD IPP Rev:B
as per ecn 10-552 DD 10.04.19 verified by:EC

Start Date: 5/26/10

Required Date: 6/03/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-607-411		Manufactured	No			110	Each	2.0000	1	1			

Quick Release Basket Mounting Installation

Location Loc Qty Loc Code

PK

2

58547

2

D3911-041 Manufactured No

110

Each

0.0000

1

1

Basket Installation Stud Assembly, Lower

D3911-043 Manufactured No

110

Each

0.0000

1

1

Aft Eyebolt Receiver Assembly

D3912-041 Manufactured No

110

Each

0.0000

1

1

Eyebolt Receiver Assembly

D4030-041 Manufactured No

110

Each

0.0000

1

1

Long Basket Assembly (350)

D4085-1 Manufactured No

110

Each

6.0000

1

1

Placard, Instructions

Location

Loc Qty

Loc Code

ENG

4

57475

4

ST112

2

57812

2

+ DSI 9524-011 C45001
per ECN 10-581
B59347

- REMOVED FROM KIT (SEE
MRP 10-6-4
ATTACHED EMAIL)

10/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A

Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

ST351	113	
-------	-----	--

114523	113	
--------	-----	--

ST357	300	
-------	-----	--

114752	300	
--------	-----	--

MS21042L4

Purchased

No

110

Each

2,629.000

6

Nut

Location	Loc Qty	Loc Code
----------	---------	----------

ST139	2	
-------	---	--

111827	2	
--------	---	--

ST300	2627	
-------	------	--

113422	80	
--------	----	--

114523	1539	
--------	------	--

114718	1000	
--------	------	--

9063	8	
------	---	--

NAS1149F0432P

Purchased

No

110

Each

775.0000

12

Washer

Location	Loc Qty	Loc Code
----------	---------	----------

ST275	775	
-------	-----	--

112940	92	
--------	----	--

114405	1	
--------	---	--

114576	182	
--------	-----	--

114718	500	
--------	-----	--

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Kim Johnston

From: L Lacelle [llacelle@dartaero.com]
Sent: Tuesday, June 08, 2010 10:24 AM
To: 'Kim Johnston'
Subject: remove from w/o's

Hi Kim,
Could you please remove the item DSI 9524-011 from w/o;'s 58321 & 59078, packaged last week.
We have removed these from the kits, since we are no longer shipping them to Capitale.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

6/8/2010

Material Requisitions

Part Number: AN960 C516L Batch Number: M111916 R/S#:
1102842 Quantity: 3
Required by: AD Date: 100610

Used for

Part Number: ENG 1100 gun Batch Number:
Approved by Purchaser: Date:

Comments:

T:\TRANSIQ\A\MATERIAL REQ-A.DOC

D350-607441
59078
Air Roberson

Opened up ~~opened~~ up to

.368

.368

David Duval

From: Marc Bellavance [mbellavance@dartaero.com]
Sent: June 10, 2010 3:43 PM
To: Duval, David
Subject: FW: D350-607-441 Basket

Here you go.

Best regards,

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 240
Fax: 613-632-9311
E-mail: mbellavance@dartaero.com
Web: www.dartaero.com



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From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: June 10, 2010 1:20 PM
To: 'Marc Bellavance'
Cc: 'Dan Stow'; 'Mike Petsche'
Subject: RE: D350-607-441 Basket

Marc,

Will this project never end???

After talking to Mike, my recommendation is for the PEC to put a step on the work order to check for this problem on assembly. If there is interference, the assembler can clean out a stainless steel washer and install it under spring pin to eliminate the interference.

It is my understanding that we are changing the whole mounting system for squirrel cheek compatability, so we don't want to put any time into revising the drawings for the existing mounting system

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Thursday, June 10, 2010 8:31 AM
To: 'David Shepherd'
Cc: 'Dan Stow'; 'Mike Petsche'
Subject: RE: D350-607-441 Basket

Forgot to attach the dwg.

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: June 10, 2010 10:30 AM
To: 'David Shepherd'
Cc: 'Dan Stow'; 'Mike Petsche'
Subject: D350-607-441 Basket
Importance: High

David,

We are about to ship a D350-607-441 Basket to a customer. Shipment is schedule for tomorrow. In the mean time we want to do a trial fit because the customer's aircraft is equipped with Squirrel Cheeks, no steps, and we want to make sure that the lid will fully open without interference.

Russ ran into a problem while performing the install.

Turns out that item D3810-1 (see attached drawing) is sunken in too deep into D3912-1 and it is not possible to mount D3912-041 on D3909-041 Lug Assembly. Interference is just about 0.040".

Possible solutions:

- 1 - Enlarge the hole of an NAS1149 washer. Bad thing about this is D3810-1 will not sit properly on the washer as it is torqued.
- 2 - Split an NAS1149 washer and make it look nice. It will require a bit of bending to insert it on D3810-1 but the plunger will sit on a larger surface once torqued.

Useless you have something else in mind, what direction should we take?

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 240

Fax: 613-632-9311

E-mail: mbellavance@dartaero.com

Web: www.dartaero.com



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